



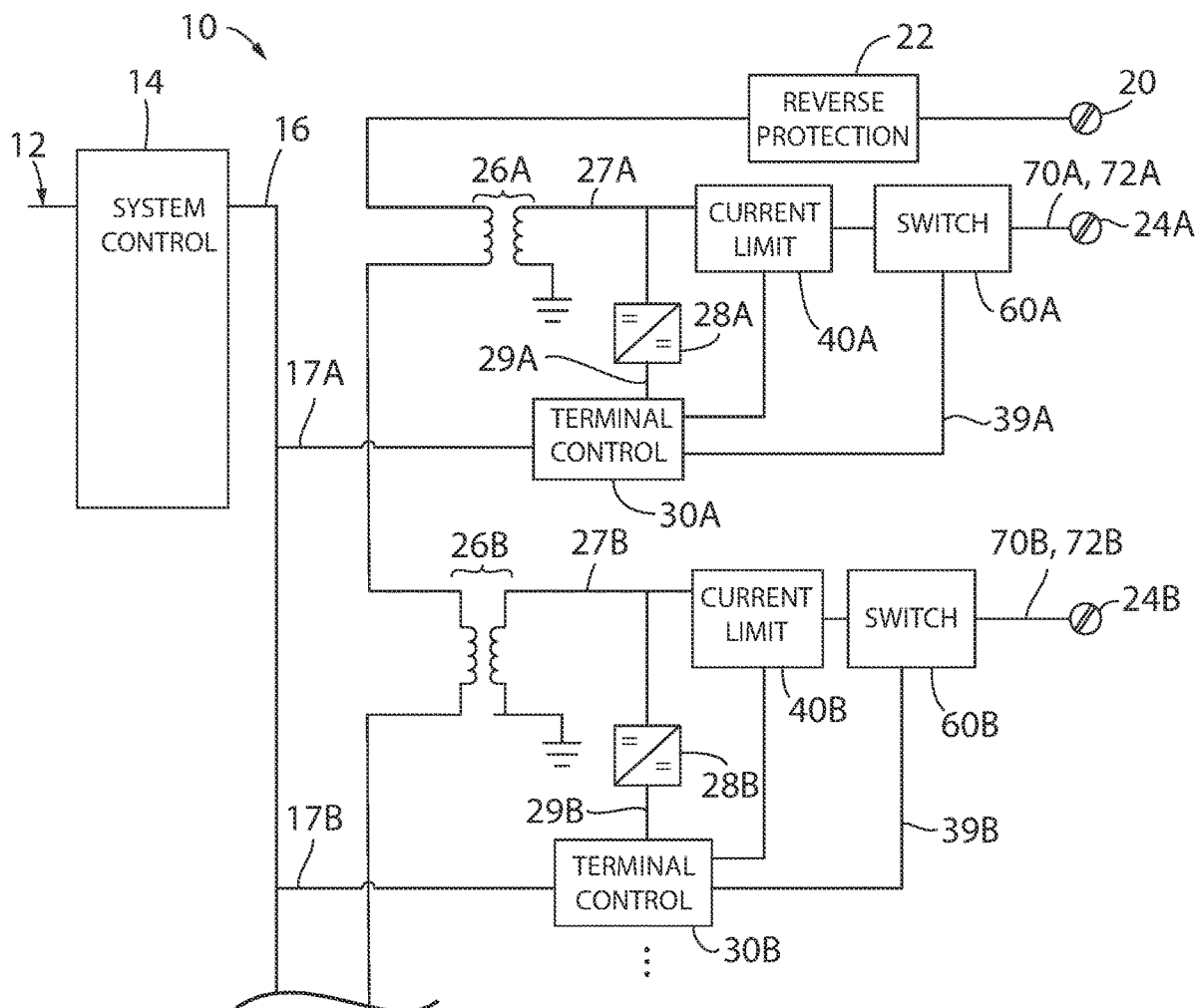
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Shah et al.(10) **Pub. No.: US 2023/0047072 A1**(43) **Pub. Date: Feb. 16, 2023**(54) **ISOLATED OUTPUT CIRCUIT FOR I/O
MODULES WITH INTERNAL OUTPUT
POWER SUPPORT**(52) **U.S. Cl.**CPC *G05B 19/0428* (2013.01); *G05B 19/0423*
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ABSTRACT(72) Inventors: **Rajesh R. Shah**, Singapore (SG);
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(PH)(21) Appl. No.: **17/980,136**(22) Filed: **Nov. 3, 2022****Related U.S. Application Data**(63) Continuation of application No. 16/550,867, filed on
Aug. 26, 2019, now Pat. No. 11,507,042.**Publication Classification**(51) **Int. Cl.**
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An output module for an industrial controller provides electrical isolation between each of the output terminals in the module. The output module receives control signals from the industrial controller indicating a desired output state for each of the output terminals and selectively connects power from the output of the electrical isolation to the output terminal. During normal operation, a switching device connects the power to the output terminal responsive to the control signal. A current sensor monitors the current conducted at the output terminal. If the current exceeds a predefined threshold, a current limit circuit clamps the current being output at the terminal. A control circuit may allow the output terminal to ride through a temporary spike in current or disable the output terminal if a fault condition is detected.



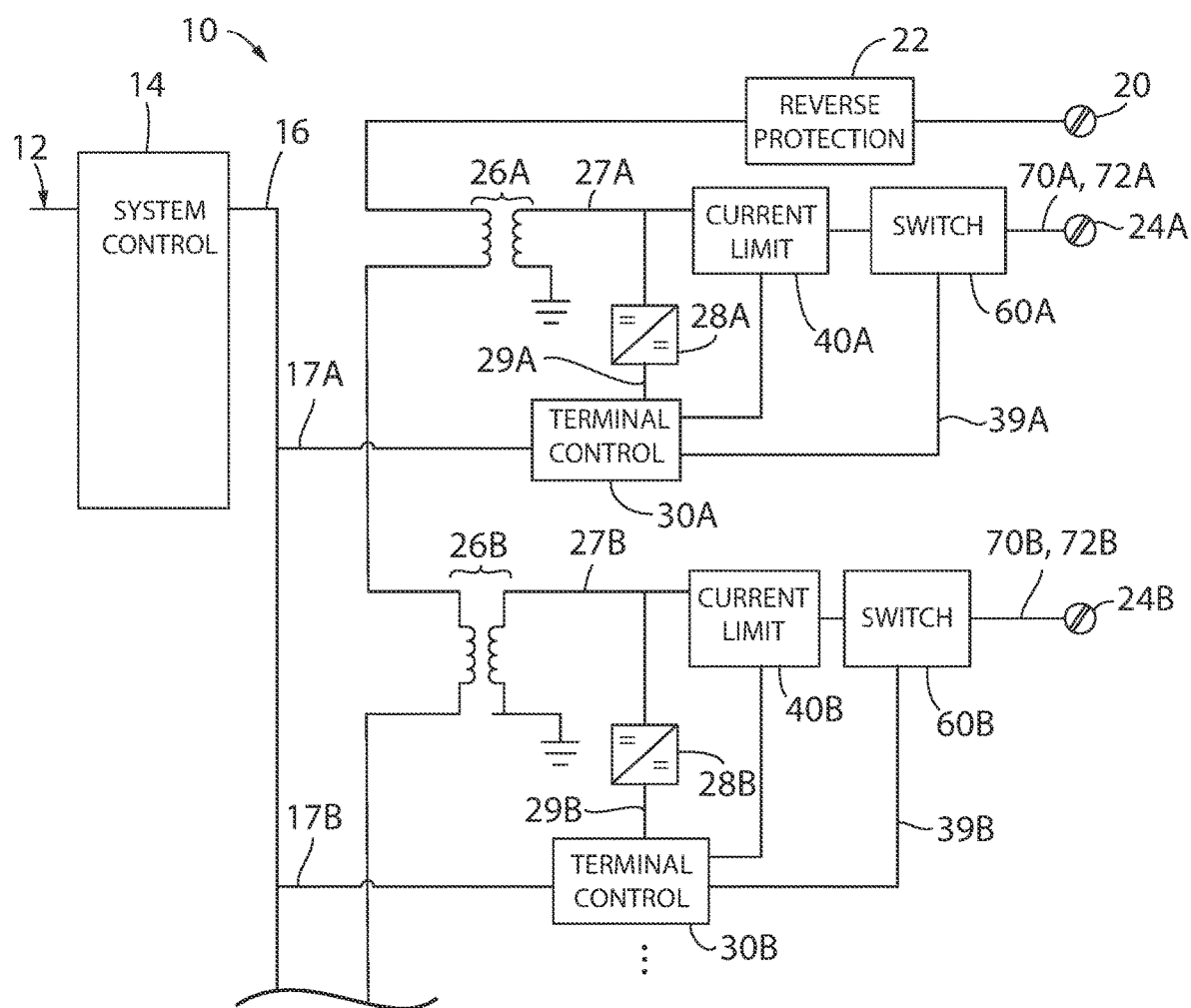
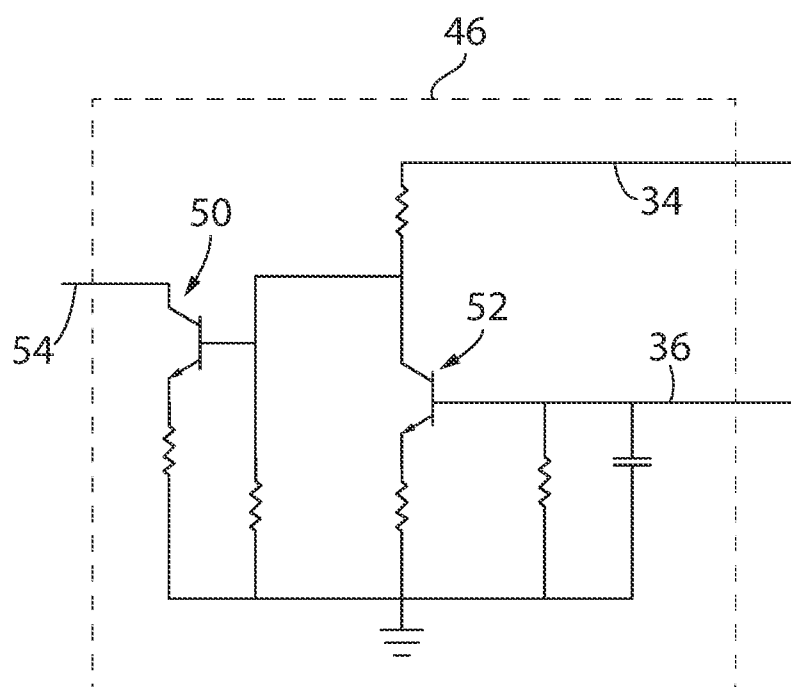
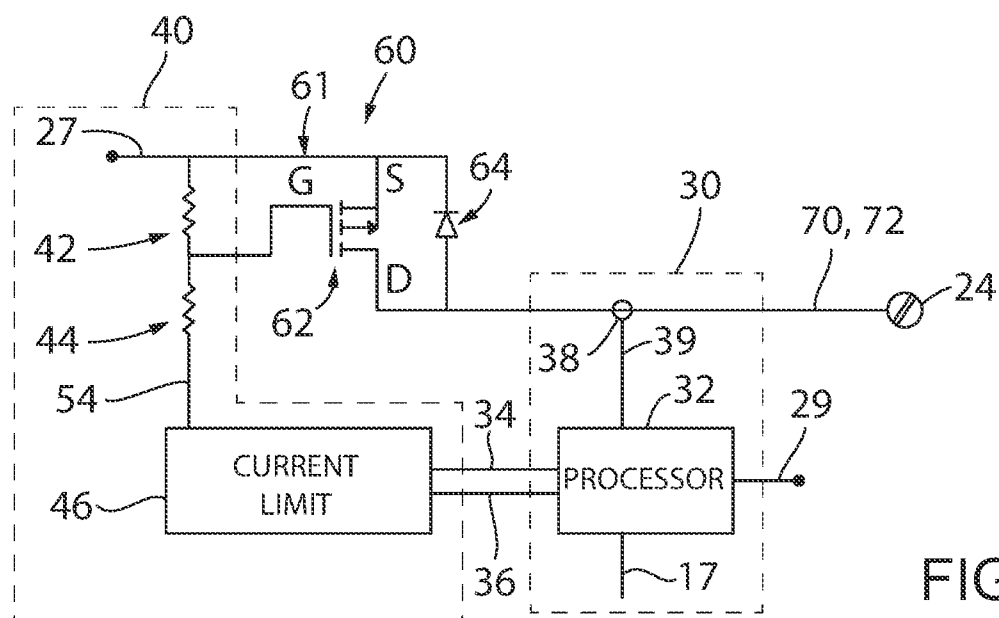


FIG. 1



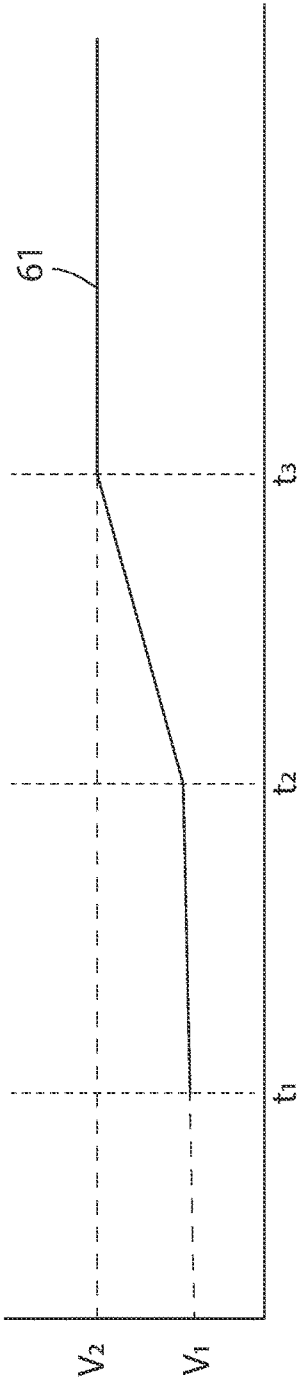


FIG. 4A

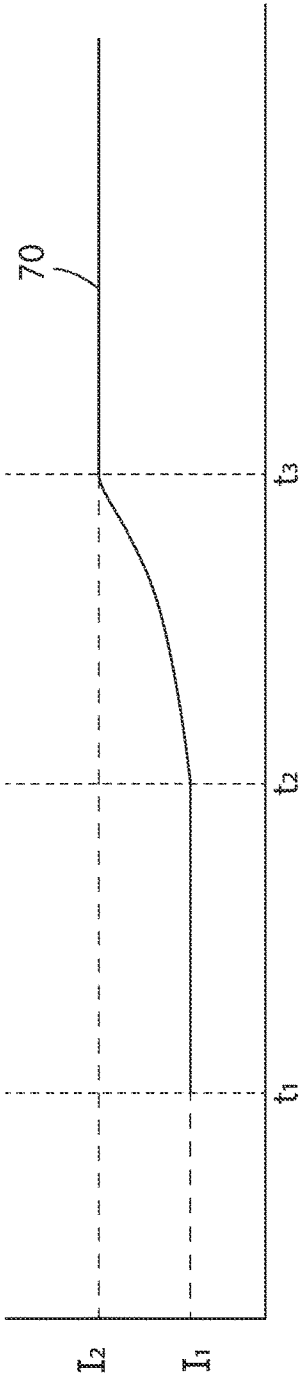


FIG. 4B

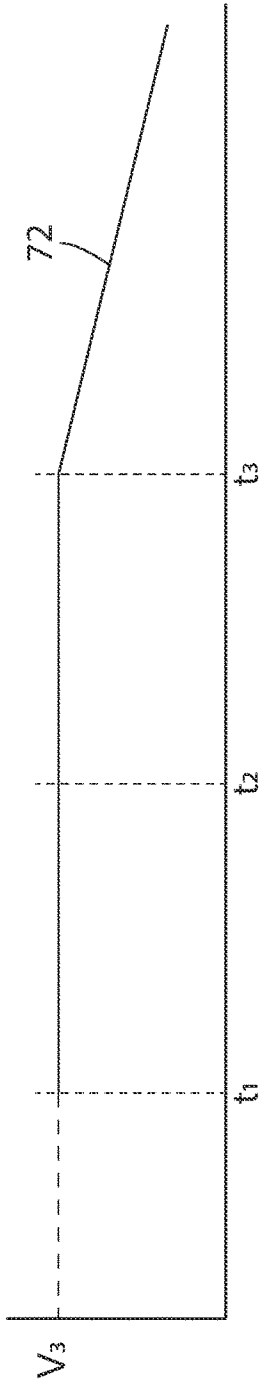


FIG. 4C

ISOLATED OUTPUT CIRCUIT FOR I/O MODULES WITH INTERNAL OUTPUT POWER SUPPORT

CROSS-REFERENCE TO RELATED APPLICATIONS

[0001] This application is a continuation of and claims priority to U.S. application Ser. No. 16/550,867, filed Aug. 26, 2019, the entire contents of which is incorporated herein by reference path.

BACKGROUND INFORMATION

[0002] The subject matter disclosed herein relates to the field of industrial automation, and more specifically, to a high current and power limiting circuit for use in an output module for an industrial controller.

[0003] Industrial controllers are specialized computer systems used for the control of industrial processes or machinery, for example, in a factory environment. Generally, an industrial controller executes a stored control program that reads inputs from a variety of sensors associated with the controlled process and machine and, sensing the conditions of the process or machine and based on those inputs and a stored control program, calculates a set of outputs used to control actuators controlling the process or machine.

[0004] Industrial controllers differ from conventional computers in a number of ways.

[0005] Physically, they are constructed to be substantially more robust against shock and damage and to better resist external contaminants and extreme environmental conditions than conventional computers. The processors and operating systems are optimized for real-time control and are programmed with languages designed to permit rapid development of control programs tailored to a constantly varying set of machine control or process control applications.

[0006] Generally, the controllers have a highly modular architecture, for example, that allows different numbers and types of input and output modules to be used to connect the controller to the process or machinery to be controlled. As part of their enhanced modularity, industrial controllers may employ input and output modules or various other modules and devices dedicated to a particular type of electrical signal and function, for example, detecting AC or DC input signals or controlling AC or DC output signals. Each of these modules may have a connector system allowing them to be installed in different combinations in a housing or rack along with other selected modules or devices to match the demands of the particular application. Multiple or individual modules or devices may be located at convenient control points near the controlled process or machine to communicate with a central industrial controller via the control network.

[0007] Output modules provide an interface between a program executing on the industrial controller and the industrial equipment or devices which the program is intended to control. Instructions in the program may determine, for example, when an actuator is to turn on or off, when a relay is to open or close, or when a motor is to start or stop. The digital signal within the industrial controller is provided to the output module. The output module receives power for the output terminals from an external power source and selectively connects the power to individual

output terminals according to the digital signals received from the control program in order to control operation of the external device.

[0008] As is known to those skilled in the art, the signal from the industrial controller is typically provided as a digital signal. The digital signal may be a logical zero and be at a ground, or common potential, for example, of zero volts (0 VDC) or the digital signal may be a logical one and be at a high reference voltage, such as 3.3 VDC or 5 VDC. The logical voltage reference, however, is commonly a different voltage than the desired output voltage at the terminal. The desired output voltage may be ± 12 VDC, ± 24 VDC, ± 48 VDC, or the like. Further, the total current requirements for all of the controlled devices connected to one output module typically exceeds the power capacity of the power supply provided for the logical circuit components. Thus, a separate power supply is often provided with one terminal of the output module configured to receive power from the power supply at the desired output voltage, where the power supply has a sufficient power rating to supply current to each controlled device at the desired output voltage. This power is selectively connected to individual output terminals by a switch where the switch for each output terminal is controlled responsive to the digital signal received for the corresponding output terminal.

[0009] Providing an external power supply to the output module to drive each of the external devices connected to that output module is not without certain drawbacks. A parallel circuit is established internally to the output module between the input terminal connected to the external power supply and each of the output terminals. Although the switch may selectively connect each output terminal to the power supply, when multiple switches are enabled and driving multiple output terminals in tandem, a conductive path is established between each of the driven output terminals. Under normal operation, this parallel operation is acceptable. If, however, one terminal experiences a high current due, for example, to an inrush current when an inductive load closes or to a short circuit condition, each of the output terminals being driven in tandem are connected to the circuit in which the high current is being conducted. A potential exists, for damage to other devices being controlled in tandem with the output terminal on which the high current is being conducted.

[0010] Thus, it would be desirable to provide an output module having multiple output terminals with electrical isolation between each of the terminals.

BRIEF DESCRIPTION

[0011] The subject matter disclosed herein describes an output module for an industrial controller having multiple output terminals with electrical isolation between each of the terminals. The output module receives control signals via an internal bus, where the control signals indicate a desired output state for each of the output terminals. An external power supply is connected to the output module to supply power for each of the output terminals. Switching circuitry within the output module selectively connects the external power supply to the output terminals responsive to the control signals.

[0012] Electrical isolation is provided between each of the output terminals in order to prevent a spike in current at one terminal from adversely impacting devices connected at any of the other terminals. According to one aspect of the

invention, the electrical isolation is provided by a transformer connected between the external power supply and each output terminal. A control circuit for each output terminal receives power from the isolated side of the transformer and controls a switch connected between the isolated side of the transformer and the output terminal to selectively connect the output of the transformer to the output terminal.

[0013] If a fault condition, switching condition, or other event occurs at the output terminal resulting in a current spike being drawn from the output terminal, the spike may cause the transformer to enter a shut-down mode in which it is unable to maintain the power supplied to the output terminal. In this shut-down mode, the voltage supplied from the transformer may drop such that it causes the control circuit to shut down. Shut down of the control circuit may result in an unintended disabling of the output terminal, and unintended shut down of the control circuitry may create an unsafe operating condition in a safety module or reduce availability of a fault tolerant module. Additionally, when the control circuit shuts down, the connection between the transformer and the output terminal may be broken, removing the current draw from the transformer. As the transformer exits the shut-down mode and the voltage level returns to a normal operating level, the control circuit is re-enabled and the terminal may be reconnected to the transformer. Reconnection of the output terminal to the transformer may re-establish a connection under the fault condition or cause another outburst spike of current to a load device at the terminal. Repeating this sequence may also result in high-frequency oscillations of current at the output terminal.

[0014] A current limiting circuit is provided between the isolated side of the transformer and the output terminal to prevent the voltage level output from the transformer from dropping enough to disable the control circuit. As a result, the control circuit remains on during periods of high current draw at an output terminal and may maintain the connection between the transformer and the output terminal, if desired. The control circuit may further be used to monitor the current flow output at each terminal and to generate a signal indicating a short circuit condition for reporting back to the industrial controller in which the output module is mounted.

[0015] According to one embodiment of the invention, an output module for an industrial controller includes a power supply terminal for receiving power from an external power supply and multiple output terminals for providing an output signal for driving an external device. The output module also includes a system control circuit to receive multiple control signals, where each control signal corresponds to one of the output terminals. The output module includes multiple current limit circuits, multiple isolation circuits, and multiple terminal control circuits, wherein each current limit circuit, isolation circuit, and terminal control circuit corresponds to one of the output terminals. Each of the isolation circuits receives the power from the power supply terminal and supplies electrically isolated power for the corresponding output terminal. Each of the control circuits receives one of the control signals and receives the electrically isolated power from one of the isolation circuits for the corresponding output terminal. Each control circuit controls one of the current limit circuits to provide the electrically isolated power as the output signal from the corresponding output terminal.

[0016] According to another embodiment of the invention, a method of limiting current in an output module for an industrial controller is disclosed, where the output module includes multiple output terminals. Multiple control signals are received at a system control circuit in the output module, and each control signal defines a desired output state of one of the output terminals. Power is received from an external power supply at a power supply terminal for the output module, and the power is supplied from the external power supply to electrical isolation circuits corresponding to each of the output terminals. Electrically isolated power is transferred from each electrical isolation circuit to a current limit circuit and a terminal control circuit within the output module for the corresponding output terminal. The electrically isolated power is selectively supplied from an output of the electrical isolation circuit via the current limit circuit to the corresponding output terminal responsive to the corresponding control signal.

[0017] According to still another embodiment of the invention, an output circuit for an output module used in an industrial controller for providing an electrically isolated output includes an output terminal, an isolation transformer, a terminal control circuit, a current limit circuit, and a switch. The output terminal provides an output signal for driving an external device. The isolation transformer has a primary winding and a secondary winding, where the primary winding receives power from a power supply terminal on the output module, and the secondary winding supplies electrically isolated power for the output terminal. The terminal control circuit receives a control signal from a system control circuit on the output module, generates a first intermediate output signal to enable the output signal for the output terminal, and generates a second intermediate output signal corresponding to current limited operation of the output terminal. The current limit circuit receives the first and second intermediate output signals from the terminal control circuit. The current limit circuit includes a first electronic switching device controlled by the first intermediate output signal to enable the output signal and a second electronic switching device controlled by the first and second intermediate output signals to enable the current limited operation of the output terminal. The switch is selectively controlled by the current limit circuit to provide the electrically isolated power as the output signal.

[0018] These and other advantages and features of the invention will become apparent to those skilled in the art from the detailed description and the accompanying drawings. It should be understood, however, that the detailed description and accompanying drawings, while indicating preferred embodiments of the present invention, are given by way of illustration and not of limitation. Many changes and modifications may be made within the scope of the present invention without departing from the spirit thereof, and the invention includes all such modifications.

BRIEF DESCRIPTION OF THE DRAWINGS

[0019] Various exemplary embodiments of the subject matter disclosed herein are illustrated in the accompanying drawings in which like reference numerals represent like parts throughout, and in which:

[0020] FIG. 1 is a schematic representation of a circuit to limit high current output at terminals of an output module for an industrial controller according to one embodiment of the invention;

[0021] FIG. 2 is a partial schematic representation of the circuit of FIG. 1 for a single output terminal;

[0022] FIG. 3 is a schematic representation of one embodiment of the current limit circuit of FIG. 1;

[0023] FIG. 4A is a graphical representation of the voltage measured at the output of the isolation transformer of FIG. 1 during various states of operation;

[0024] FIG. 4B is a graphical representation of the current measured at one output terminal of FIG. 1 during various states of operation; and

[0025] FIG. 4C is a graphical representation of the voltage measured at one output terminal of FIG. 1 during various states of operation.

[0026] In describing the various embodiments of the invention which are illustrated in the drawings, specific terminology will be resorted to for the sake of clarity. However, it is not intended that the invention be limited to the specific terms so selected and it is understood that each specific term includes all technical equivalents which operate in a similar manner to accomplish a similar purpose. For example, the word “connected,” “attached,” or terms similar thereto are often used. They are not limited to direct connection but include connection through other elements where such connection is recognized as being equivalent by those skilled in the art.

DETAILED DESCRIPTION

[0027] The various features and advantageous details of the subject matter disclosed herein are explained more fully with reference to the non-limiting embodiments described in detail in the following description.

[0028] Turning initially to FIG. 1, an output circuit 10 for an output module used in an industrial controller includes multiple sub-circuits. According to the illustrated embodiment, the output circuit 10 includes a system control circuit 14 and a reverse protection circuit 22. For each output terminal 24, the output circuit 10 further includes an electrical isolation circuit 26, a terminal control circuit 30, a current limit circuit 40, and a switching circuit 60. The output circuit 10 is divided into the sub-circuits for ease of illustration and discussion, and the illustrated embodiment is not intended to be limiting. The illustrated embodiment is one embodiment of the invention and it is contemplated that various elements discussed with respect to one sub-circuit may be incorporated into another sub-circuit to achieve an identical function without deviating from the scope of the invention.

[0029] The illustrated system control circuit 14 provides an interface between the industrial controller and the output module. The system control circuit 14 may include, for example, a backplane connector operative to connect to a backplane such that the system control circuit 14 may receive digital signals 12 from a processor module or from other modules within the industrial controller. The processor module (not shown) may execute a control program to generate desired operation of devices controlled by the industrial controller. The control program generates digital signals 12 which are transmitted to the output module via the backplane and received by the system control circuit 14.

[0030] The digital signals 12 may be passed to the output module in various forms. Discrete signals may be passed over dedicated channels on a data bus. Optionally, the data signals 12 may be included in a data packet and transmitted via the data packet over the backplane to the output module.

The system control circuit 14 may include, for example, buffers to receive the data packets and a processor executing instructions to receive the data packet and extract the data signals. Optionally, the processor may perform some further processing on the data signals 12 prior to using the data signals to enable/disable individual output terminals 24 on the output module.

[0031] A data bus 16 is provided as an output from the system control circuit 14 to each of the output terminals 24. Appropriate interface circuitry may be provided within a terminal control circuit 30 for each output terminal to extract control signals 17 from the bus 16. Optionally, the bus 16 may consist of multiple individual traces on which each control signal 17 is separately conducted from the system control circuit 14 to the corresponding terminal control circuit 30 for each output terminal. For ease of illustration, two output terminals 24A, 24B, with associated control circuitry for each output terminal, are illustrated in FIG. 1. It is contemplated that the output module may include a single output terminal 24 or may include still additional output terminals beyond the two illustrated terminals 24. Output modules may be configured, for example, with eight (8) or sixteen (16) output terminals 24, where the control circuitry for one output terminal is duplicated for each output terminal in the module.

[0032] With reference also to FIG. 2, the terminal control circuit 30 for each output terminal 24 may include a microprocessor 32. The microprocessor 32 is powered by a control voltage 29 received as an output from the isolation circuit 26. The microprocessor 32 receives the control signal 17 as an input to indicate when the corresponding output terminal 24 is to be energized. A pair of outputs 34, 36 are provided to the current limit circuit 46, where a first output 34 indicates that the output terminal 24 is to be energized and a second output 36 indicates that the output terminal is to operate in a current limiting state. According to one embodiment of the invention, the control signal 17 and the control voltage 29 are the same signal. The system control circuit 14 may output the control signal 17 as an enabling voltage to the microprocessor 32. The enabling voltage may both energize the microprocessor and indicate that the output terminal 24 is to be energized. When used as an enabling voltage and as a control signal 17, the control voltage 29 may also be provided to the current limit circuit 46 as the first output signal 34, indicating that the output terminal is to be energized.

[0033] A current sensor 38 is provided to generate a current feedback signal 39 corresponding to the current being conducted at the output terminal 24. As illustrated in FIG. 2, the current sensor 38 is incorporated in the terminal control circuit 30. As illustrated in FIG. 1, the current sensor (although not shown in FIG. 1) is incorporated in the switch circuit 60 and provides the current feedback signal 39 to the terminal control circuit 30. The current sensor 38 may be, for example, a current sensing resistor connected in series with the output terminal 24. A voltage drop across the current sensing resistor may be measured and provided as the current feedback signal 39 which is input to the microprocessor 32.

[0034] It is contemplated that the microprocessor 32 may be configured to receive the control signal 17 and the current feedback signal 39 as input signals, to execute stored instructions, and to generate the output signal(s) 34, 36 responsive to the input signals. Optionally, the micropro-

cessor may be a dedicated integrated circuit (IC) performing a single function, such as a comparison function, where the current feedback signal 39 is compared to a threshold and the second output signal 36 is generated when the current conducted at the output terminal 24 exceeds the threshold. According to still another embodiment of the invention, the microprocessor 32 may be a field programmable gate array (FPGA) or an application specific integrated circuit (ASIC) configured to generate the output signal(s) 34, 36 responsive to the measured current feedback signal 39 and control signal 17. A single IC may be provided for each output terminal 24 or one IC may incorporate multiple control circuits 30 to control operation of multiple output terminals 24.

[0035] With reference also to FIG. 3, the current limit circuit 46 is used, in combination with the control circuit 30 to control operation of the switching circuit 60. The switching circuit 60 includes a field-effect transistor (FET) 62, such as a metal-oxide-semiconductor field-effect transistor (MOSFET). The FET 62 is controlled in one of three operating states to determine the output of the corresponding output terminal 24. In a first operating state, the FET 62 is disabled, preventing current conduction through the device and turning off the output terminal 24. In a second operating state, the FET 62 is enabled, or operating, in a saturation mode, allowing “full” conduction through the FET and turning on the output terminal 24. The first two operating states are considered the “normal” operating states for each output circuit. A third operating state is also provided for a “current limiting” operating state. The FET 62 is operated in a linear mode, where the voltage supplied to the gate is varied such that the FET operates as a variable resistor to vary the amount of current conducted through the FET.

[0036] In operation, the current limit circuit 46 outputs a switching signal 54 to the switching circuit 60 to select the desired operating mode of the FET 62 and, thereby limit the current output from the output terminal 24. When the control signal 17 indicates the corresponding output terminal 24 is to be turned off, the control circuit 30 and the current limit circuit 46 operate in tandem to disable the FET 62 and operate in the first operating mode. When the control signal 17 indicates the corresponding output terminal 24 is to be turned on, the control circuit 30 and the current limit circuit 46 operate in tandem to supply a first voltage to the gate terminal of the FET, causing the FET to operate in the saturation mode. If the control circuit 30 detects a signal from the current sensor 38 indicating the current at the output terminal 24 exceeds a predefined threshold, the control circuit 30 and current limit circuit 46 operate in tandem to supply a second voltage to the gate terminal of the FET, causing the FET to operate in a linear mode, restricting the amount of current output from the terminal.

[0037] Power to drive external devices connected to each output terminal 24 is supplied to the output module by an external power source. The external power source may be a power supply providing, for example, 12 VDC, 24 VDC, 48 VDC or any other suitable voltage level which is connected to a first terminal 20 of the output module. This first terminal 20 is also referred to herein as a power supply terminal. The power source is configured to have a sufficient power rating to supply current at the desired output voltage for each of the output terminals 24 in the output module to which it is connected. A reverse protection circuit 22 may be provided

to prevent damage to the output module if the external power source is erroneously connected to the output module with a reverse polarity.

[0038] Although the power for each output terminal 24 is provided from a single power source, the output module includes electrical isolation provided between output terminals to prevent a fault condition at one terminal from damaging devices connected at other terminals. An electrical isolation device 26 is provided for each output terminal between the power supply terminal 20 and the circuitry to control operation of the corresponding output terminal 24. According to the embodiment in FIG. 1, a first output terminal 24A includes a first isolation transformer 26A, and a second output terminal 24B includes a second isolation transformer 26B. Each isolation transformer 26 includes a primary winding electrically connected to the power supply terminal 20 and a secondary winding at which a control voltage 27, which is electrically isolated from the power supply voltage, is provided. A DC-to-DC power converter 28 receives the control voltage 27 as an input and outputs one or more DC voltages, such as 5 VDC, 3.3 VDC, or the like, suitable to supply power to ICs, processors, or other electrical devices within the control circuit 30 for the corresponding output terminal 24.

[0039] With the DC voltage from the output of the DC-to-DC power converter 28 enabling each control circuit 30A, 30B, the control circuit monitors the digital signal 17A, 17B received from the system control circuit 14 to set the respective output terminal 24A, 24B to the desired state as indicated by the digital signal. When the digital signal 17 is off, or set to a logical zero, both the first output 34 and the second output 36 from the control circuit 30 are off. As illustrated in FIGS. 2 and 3, the first output 34 from the control circuit is used to enable the first transistor 50 in the current limit circuit, and the second output 36 from the control circuit is used to enable the second transistor 52 in the current limit circuit 46. Thus, when both the first and second outputs are off, the first transistor 50 and the second transistor 52 in the current limit circuit are similarly disabled. The output 54 of the current limit circuit is similarly off, which disables the FET 62 in the switching circuit 60. When the digital signal 17 is on, or set to a logical one, the first output 34 from the control circuit is similarly on, or set to a logical one, which enables the first transistor 50 in the current limit circuit. The output 54 of the current limit circuit is set to a first voltage, which causes the FET 62 to enter the saturation mode. As previously indicated, the first output 34 may also be tied directly to the digital signal 17 such that the digital signal 17 is used both to enable the control circuit 30 and to enable the first transistor 50 in the current limit circuit 46, thereby enabling the FET.

[0040] The control circuit 30 monitors the current feedback signal 39 from the current sensor 38 to control operation of the second transistor 52 in the current limit circuit 46. According to one embodiment of the invention, the current feedback signal 39 is converted to a digital signal, either via the current sensor 38 or via an analog-to-digital (A/D) converter connected in series between the current sensor 38 and the processor 32. The processor 32 receives the digital current feedback signal and compares the value to a preset threshold which may be stored in memory either within or in communication with the processor 32. According to another embodiment of the invention, an external reference value may be provided to the processor 32 either digitally or

via an analog signal which may be converted to a digital signal prior to comparison with the current feedback signal 39. According to still another embodiment of the invention, the processor 32 may be a dedicated comparator circuit which receives the current feedback signal 39 and a reference signal as analog signals and compares the two signals. In any of these embodiments, the reference signal or stored value define a threshold for a maximum current value desired at the output terminal 24. When the current present at the output terminal 24 (as indicated by the current feedback signal 39) is less than the threshold, the second output of the control circuit 30, as set by the processor 32 or comparator, is off or set to a logical zero. When the current present at the output terminal 24 is greater than the threshold, the second output 36 of the control circuit is on or set to a logical one by the processor 32 or comparator. The second output 36 from the control circuit 30 is, in turn, provided to the current limit circuit 46.

[0041] The current limit circuit 46 uses the second output 36 to keep the current present at the output terminal 24 below a desired maximum value. A graphical representation of the operation of the current limit circuit 46 at one output terminal 24 is shown in FIGS. 4A-4C. At time t_1 , the control signal 17 for the output terminal is set. The first output signal 34 is set either by the processor 32 or directly via the control signal 17 to enable the first transistor 50 in the current limit circuit 46. With the first transistor 50 enabled and the second transistor 52 disabled the FET 62 is enabled to operate in saturation mode. Under normal operation, illustrated between times t_1 and t_2 , an input voltage 61 is drawn from the isolation transformer 26 and is present at a first voltage level, V_1 . The output terminal 24 has an output current 70 and an output voltage 72 present at a first current level, I_1 , and an output voltage level, V_3 , respectively. At time t_2 , the current 70 at the output terminal 24 begins to increase. The increase may be caused by a change in load, short circuit, or other operating or fault condition. As the current 70 increases, the input voltage 61 drawn from the isolation transformer begins to increase as well. At time, t_3 , the output current reaches the maximum threshold. The control circuit 30 sets the second output 36 and the current limit 46 enables the second transistor 52. Enabling the second transistor 52 causes the FET 62 to operate in a linear mode. The output current 70 remains constant, but the output voltage 72 is reduced to prevent further increase in the output current. Operating the FET 62 in this manner to limit the output current 70 also prevents the input voltage 61 drawn from the isolation transformer 26 from increasing further. As a result, the isolation transformer 26 remains active and is prevented from entering a shut down mode. As a further result, the control voltage 27 supplied to the DC-to-DC converter 28 also remains present, allowing the control circuit 30 to continue operation and to maintain control over the output terminal 24.

[0042] As another aspect of the invention, an indication of the current limit condition may be provided to the industrial controller in which the output module is located. In one embodiment of the invention, the current feedback signal 39 may be provided via the system control circuit 14 to a backplane or data bus and communicated to a processor module. Optionally, the second output signal 36 may be provided to the processor module. When the processor module is alerted of the current limiting operation, it may be configured to post an alarm or fault message, to take action

to remove power from the output terminal, or to take any other suitable action according to the application requirements.

[0043] It should be understood that the invention is not limited in its application to the details of construction and arrangements of the components set forth herein. The invention is capable of other embodiments and of being practiced or carried out in various ways. Variations and modifications of the foregoing are within the scope of the present invention. It also being understood that the invention disclosed and defined herein extends to all alternative combinations of two or more of the individual features mentioned or evident from the text and/or drawings. All of these different combinations constitute various alternative aspects of the present invention. The embodiments described herein explain the best modes known for practicing the invention and will enable others skilled in the art to utilize the invention.

We claim:

1. An output module for an industrial controller, the output module comprising:
 - a power supply terminal for receiving power from an external power supply;
 - a plurality of output terminals for providing an output signal for driving an external device;
 - a system control circuit to receive a plurality of control signals, wherein each of the plurality of control signals corresponds to one of the plurality of output terminals;
 - a plurality of current limit circuits, wherein each of the plurality of current limit circuits corresponds to one of the plurality of output terminals;
 - a plurality of isolation circuits, wherein each of the plurality of isolation circuits:
 - corresponds to one of the plurality of output terminal,
 - receives the power from the power supply terminal, and
 - supplies electrically isolated power for the corresponding output terminal;
 - a plurality of terminal control circuits, wherein each of the plurality of control circuits:
 - corresponds to one of the plurality of output terminals,
 - receives one of the plurality of control signals for the corresponding output terminal,
 - receives the electrically isolated power from one of the plurality of isolation circuits for the corresponding output terminal, and
 - controls one of the plurality of current limit circuits to provide the electrically isolated power as the output signal from the corresponding output terminal.
2. The output module of claim 1, wherein each of the plurality of isolation circuits comprises an isolation transformer having a primary winding and a secondary winding, wherein the primary winding is electrically connected to the power supply terminal and the secondary winding provides the electrically isolated power to the corresponding current limit circuit and the corresponding terminal control circuit.
3. The output module of claim 1, further comprising a plurality of switches, wherein each of the plurality of switches corresponds to one of the plurality of output terminals and is operatively connected between the corresponding current limit circuit and the corresponding output terminal.
4. The output module of claim 3, wherein each of the plurality of switches selectively connects the corresponding isolation circuit to the corresponding output terminal in one of three operating states, and wherein the three operating

states include an off operating state, an on operating state, and a current limited operating state.

5. The output module of claim 1, wherein each of the plurality of terminal control circuits generates a first intermediate output signal to enable the output signal for the corresponding output terminal and a second intermediate output signal corresponding to current limited operation of the corresponding output terminal.

6. The output module of claim 5, wherein each of the plurality of current limit circuits receives the first and second intermediate output signals from the corresponding terminal control circuit, and wherein each of the plurality of current limit circuits further comprises:

- a first electronic switching device controlled by the first intermediate output signal to enable an output of the current limit circuit; and
- a second electronic switching device controlled by the first and second intermediate output signals to enable a current limited operating state.

7. The output module of claim 5, wherein each of the plurality of terminal control circuits further comprises a processor operative to:

- receive the control signal for the corresponding output terminal from the system control circuit,
- generate the first intermediate output signal and the second intermediate output signal responsive to the control signal for the corresponding output terminal,
- output the first intermediate output signal to the current limit circuit, and
- output the second intermediate output signal to the current limit circuit.

8. The output module of claim 7, further comprising a plurality of current sense circuits, wherein each of the plurality of current sense circuits corresponds to one of the plurality of output terminals and is operative to generate a current feedback signal corresponding to an amount of current output at the corresponding output terminal, and wherein the processor is further operative to:

- receive the current feedback signal for the corresponding output terminal, and
- generate the first intermediate output signal and the second intermediate output signal responsive to the control signal and responsive to the current feedback signal for the corresponding output terminal.

9. The output module of claim 1, wherein the system control circuit includes a backplane connector to receive the plurality of control signals over a backplane from a processor module for the industrial controller.

10. A method of limiting current in an output module for an industrial controller, wherein the output module includes a plurality of output terminals, the method comprising the steps of:

- receiving a plurality of control signals at a system control circuit in the output module, wherein each control signal defines a desired output state of one of the plurality of output terminals;
- receiving power from an external power supply at a power supply terminal for the output module;
- supplying the power from the external power supply to a plurality of electrical isolation circuits, wherein each of the plurality of electrical isolation circuits corresponds to one of the plurality of output terminals;
- transferring electrically isolated power from each of the plurality of electrical isolation circuit to a current limit

circuit and a terminal control circuit within the output module for the corresponding output terminal;

selectively supplying the electrically isolated power from an output of the electrical isolation circuit via the current limit circuit to the corresponding output terminal responsive to the corresponding control signal.

11. The method of claim 10, wherein each of the plurality of electrical isolation circuits comprises an isolation transformer having a primary winding and a secondary winding, wherein the primary winding is electrically connected to the power supply terminal and the secondary winding provides the electrically isolated power to the corresponding current limit circuit and the corresponding terminal control circuit.

12. The method of claim 10, further comprising the step of selectively controlling a switch corresponding to each output terminal with an output from the current limit circuit, wherein the switch is electrically connected between an output of the electrical isolation circuit and the corresponding output terminal.

13. The method of claim 12, wherein the switch corresponding to each output terminal is selectively controlled by an output from the current limit circuit in one of three operating states, and wherein the three operating states include an off operating state, an on operating state, and a current limited operating state.

14. The method of claim 10, further comprising the steps of:

- generating a first intermediate output signal from each terminal control circuit to enable an output signal for the corresponding output terminal; and
- generating a second intermediate output signal from each terminal control circuit to enable a current limited output signal for the corresponding output terminal.

15. The method of claim 14 further comprising the steps of:

- transmitting the first and second intermediate output signals from each terminal control circuit to the corresponding current limit circuit;
- controlling a first electronic switching device in each current limit circuit by the first intermediate output signal to enable the output signal; and
- controlling a second electronic switching device in each current limit circuit by the first and second intermediate output signals to enable the current limited output signal.

16. The method of claim 14, wherein each terminal control circuit includes a processor, the method further comprising the steps of:

- receiving at the processor the control signal for the corresponding output terminal from the system control circuit;
- generating with the processor the first intermediate output signal and the second intermediate output signal responsive to the control signal for the corresponding output terminal;
- outputting the first intermediate output signal from the processor to the current limit circuit; and
- outputting the second intermediate output signal from the processor to the current limit circuit.

17. The method of claim 16 further comprising the steps of:

- receiving a current feedback signal at the processor from a current sense circuit for the corresponding output terminal, and

generating the first intermediate output signal and the second intermediate output signal responsive to the control signal and responsive to the current feedback signal for the corresponding output terminal.

18. The method of claim **10**, further comprising the step of transmitting the plurality of control signals over a backplane from a processor module for the industrial controller to a backplane connector in the system control circuit.

19. An output circuit for an output module used in an industrial controller for providing an electrically isolated output, the output circuit comprising:

an output terminal for providing an output signal for driving an external device;

an isolation transformer having a primary winding and a secondary winding, wherein the primary winding receives power from a power supply terminal on the output module, and the secondary winding supplies electrically isolated power for the output terminal;

a terminal control circuit receiving a control signal from a system control circuit on the output module, generating a first intermediate output signal to enable the

output signal for the output terminal, and generating a second intermediate output signal corresponding to current limited operation of the output terminal;

a current limit circuit receiving the first and second intermediate output signals from the terminal control circuit, wherein the current limit circuit includes a first electronic switching device controlled by the first intermediate output signal to enable the output signal and a second electronic switching device controlled by the first and second intermediate output signals to enable the current limited operation of the output terminal; and a switch selectively controlled by the current limit circuit to provide the electrically isolated power as the output signal.

20. The output module of claim **19**, wherein the switch selectively connects the secondary winding of the isolation transformer to the output terminal in one of three operating states, and wherein the three operating states include an off operating state, an on operating state, and a current limited operating state.

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